

Standard din 8555: e 10-um-70-gtrz

FEATURES

Carver-9460 is fine ripple-free smooth seam deposits ledeburitic structure comprising of premium carbides of niobium, moly supplanted by chromium. Weld metal is slagfree with negligible spatter heavy coated electrode has high efficiency of 240% it resists extreme wear forces, most eminently, upto 600°c

APPLICATIONS

Coke discharging tools, hammer crushers for cement
 Chutes mixer blades sinter crushers fine grate bars in mining

OPERATIONAL CHARACTERISTICS

- Requires no external shielding to produce sound weld deposits.
- Operates over a wide amperage range using DC + (reverse polarity) (electrode+).
- Can be used with variable speed wire feeders and any conventional power source.
- No special welding techniques are required.
- Clean welding area, no preheat, stringer beading is recommended.

TECHNICAL DATA

| | | | | | | | | |
|----------------------|---|----------------------|-----|----|-----|-----|---|---|
| Alloy Type | : | C, Nb, Mo, Cr, W, V. | | | | | | |
| Machinability | : | Non-Machinable | | | | | | |
| Weld Metal chemistry | : | C | Si | Cr | Nb | Mo | W | V |
| | | 5.3 | 2.1 | 29 | 5.5 | 5.5 | | |

RECOMMENDED CURRENT RANGE

| ELECTRODES | | | |
|------------|---------|---------|---------|
| SIZE (mm) | 3.15 | 4.00 | 5.00 |
| AMPS | 100-130 | 130-180 | 170-220 |

| FLUX CORED WIRES | | | |
|------------------|---------|---------|---------|
| SIZE (mm) | 2.4 | 2.8 | 3.2 |
| AMPS | 360-400 | 410-460 | 480-520 |

CARVER 9460

**PREMIUM CARBIDES RESISTING ABRASION, EROSION
 AND THERMAL, CORROSION FORCES**